

Work Order ID 72485

Tuesday, July 26, 2011 11:51:14 AM

Page 1

U/R



Item ID: D407-667-105TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail

Start Date: 7/26/2011 Start Qty: 1.00
Required Date: 8/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: 11-07-26 Date: 11-07-26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D407-667-145	Rev C U/R								
100	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249 2-Turn first side as per Folio FA249 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
110	QC1- Inspect dimensions to dimension sheet	0.00							
QC	Memo	0.00							
Quality Control									

11/07/27

11-7-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki	Memo	0.00				1	Ø		
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA249								
	2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
	3-Remove sand and plugs								
	4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145 inside of Cuff(Do not engrave on outside of tube)								
130	QC1- Inspect dimensions to dimension sheet	0.00							
QC	Memo	0.00				1	Ø		
Quality Control									

MML 11/07/27

R 11-7-28

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Item ID: D407-667-105TRN

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop



Start Date: 7/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
150 HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo	0.00 0.00							
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Handwritten signature 11-07-29 1P

Handwritten signature 11-07-29
SAD

Handwritten signature 11-8-2

W/O:		WORK ORDER CHANGES					
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Page 4

Accept

Setup Start

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

Run Start



Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

170

0.00

Packaging

Packaging

Memo

0.00

Packaging

Identify and stock in Kanban rack □ Location:

46



11-8-2

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

OK 11/08/02

11-08-2

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 26, 2011 11:51:20 AM

Page 1

Work Order ID: 72485

Parent Item: D407-667-105TRN

Parent Item Name: Crosstube Turning Detail




Start Date: 7/26/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:a 08.02.28 new issue EC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6010-115 		Manufactured	No			110	Each	31.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

LG

31

38343

31

MAK. 11/07/26

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 72485
Description: Crosstube Assembly	Part Number: D407-667-145
Inspection Dwg: D407-667-145 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245 ✓		vern	JF-01
	1.865	+0.005/-0.000	1.869 ✓		"	
	1.878	+0.005/-0.000	1.881 ✓		"	
	1.970	+0.005/-0.000	1.975 ✓		"	
	2.030	+0.005/-0.000	2.035 ✓		"	
	2.165	+0.005/-0.000	2.170 ✓		mirc	CNC-04
	0.125	+/-0.010	.125 ✓		vern	JF-01
	R0.063	+/-0.010	.063 ✓		RG	
	R0.500	+/-0.010	.500 ✓		"	
	R0.063	+/-0.010	.063 ✓		"	
	4.438	+/-0.030	4.438 ✓		vern	JF-01
SIDE B	2.240	+0.005/-0.000	2.245 ✓		vern	JF-01
	1.865	+0.005/-0.000	1.870 ✓		"	
	1.878	+0.005/-0.000	1.880 ✓		"	
	1.970	+0.005/-0.000	1.975 ✓		"	
	2.030	+0.005/-0.000	2.035 ✓		"	
	2.165	+0.005/-0.000	2.169 ✓		mirc	CNC-04
	0.125	+/-0.010	.125 ✓		vern	JF-01
	R0.063	+/-0.010	.063 ✓		RG	
	R0.500	+/-0.010	.500 ✓		"	
	R0.063	+/-0.010	.063 ✓		"	
	4.438	+/-0.030	4.438 ✓		vern	JF-01
	113.20	+/-0.020	113.20 ✓		tape	mm.c-02

Measured by: MML RR	Audited by: [Signature]	Preliminary Approval:
Date: 11/07/26	Date: 11.07.29	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ	
D	11.06.21	Tolerance revised for 4.438 dimension	KJ	[Signature]

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Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72485

UNDER REVIEW

RELEASED
03/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN 06-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D407-667-145	SHEET 1 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASSY (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

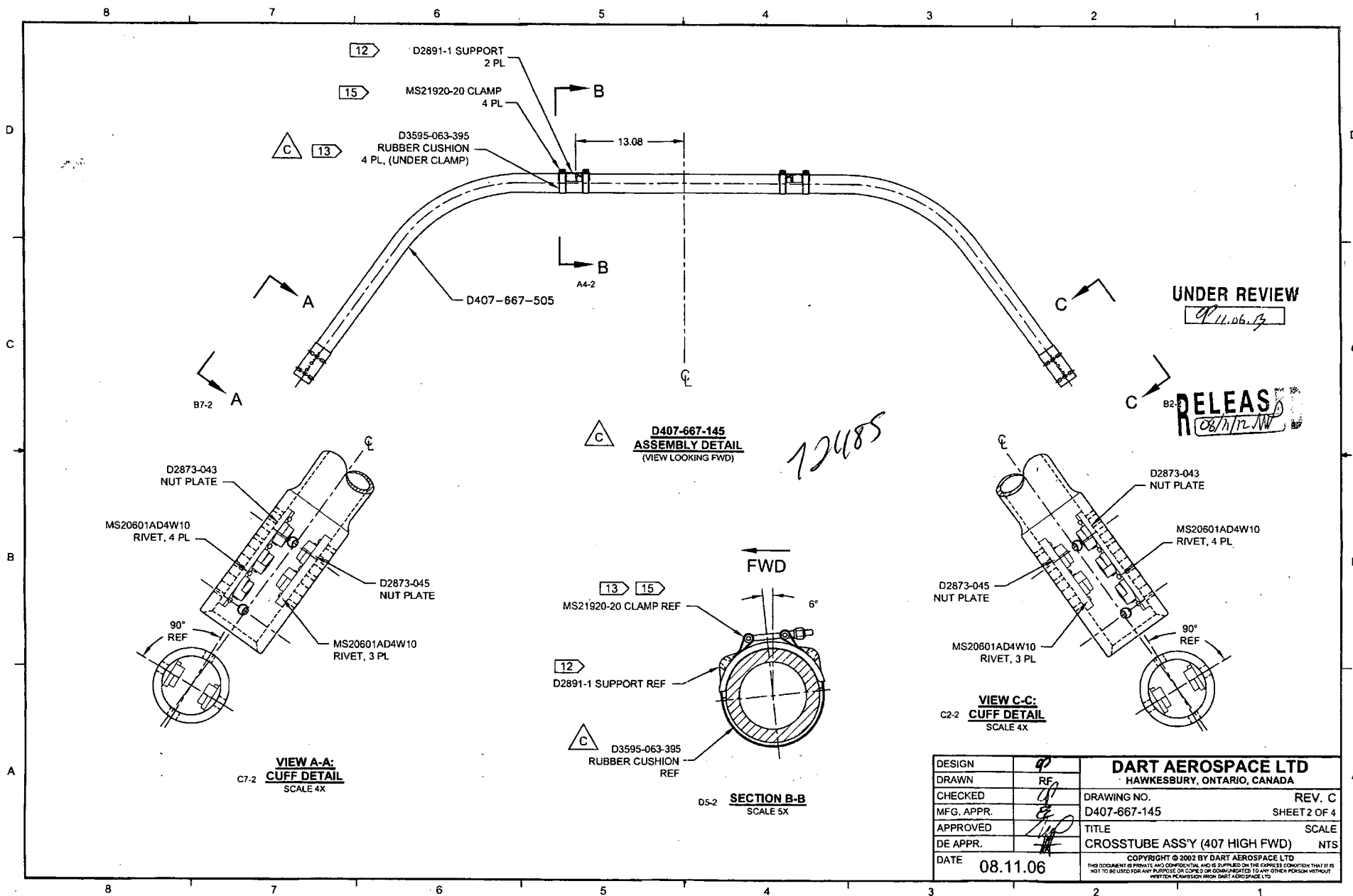
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DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	97	D407-667-145	SHEET 2 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASSY (407 HIGH FWD)	NTS
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8

7

6

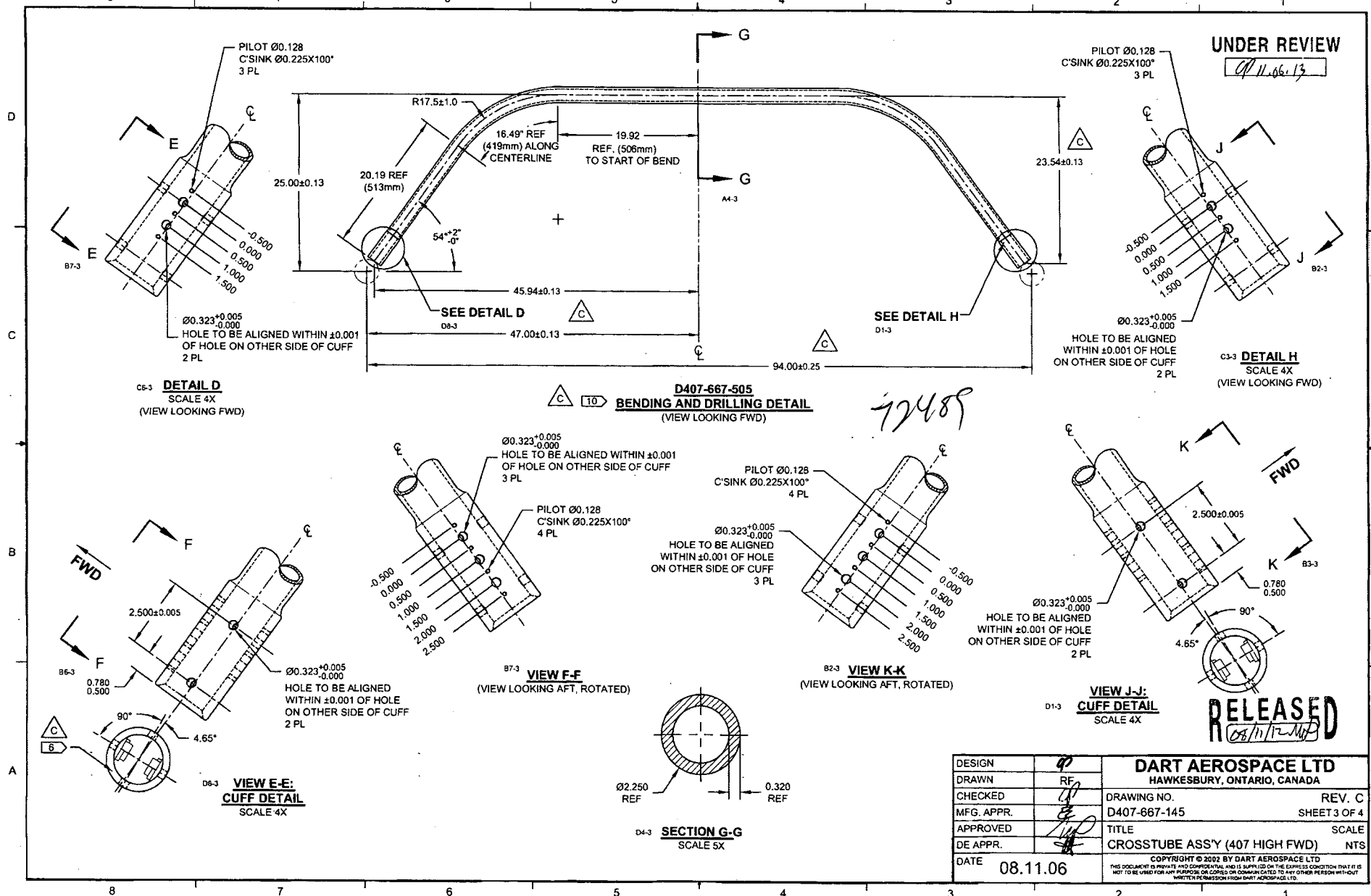
5

4

3

2

1



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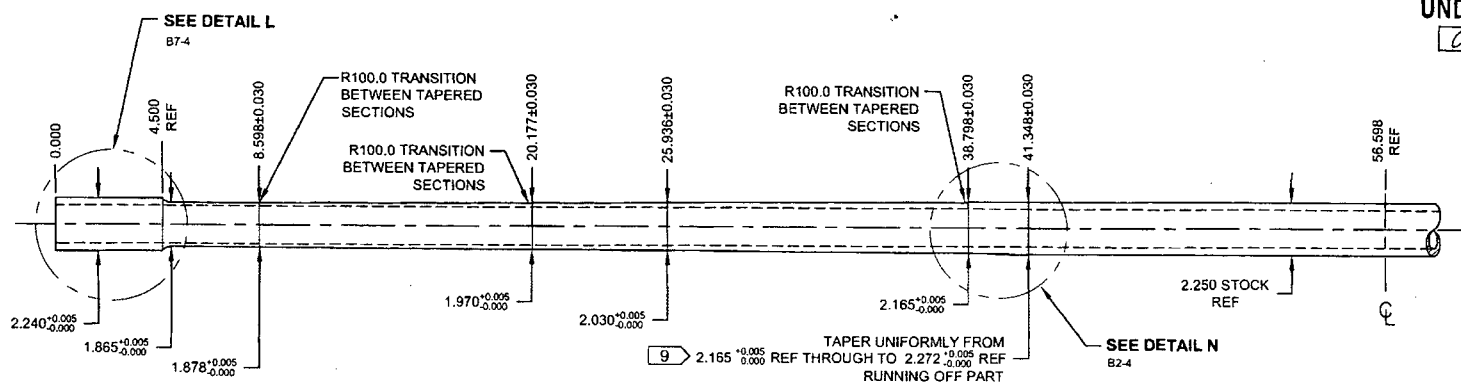
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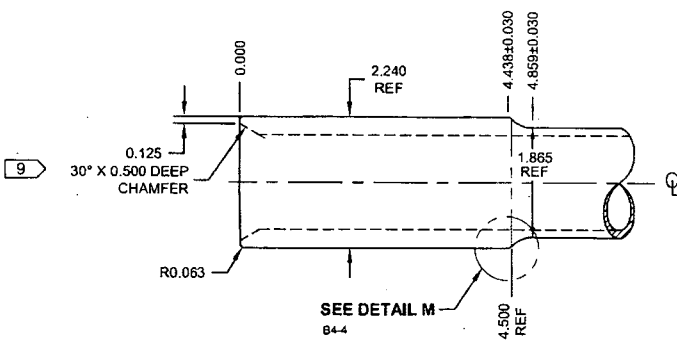
UNDER REVIEW

11.06.13

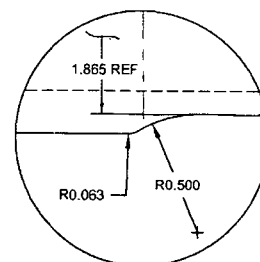


C TURNING DETAIL

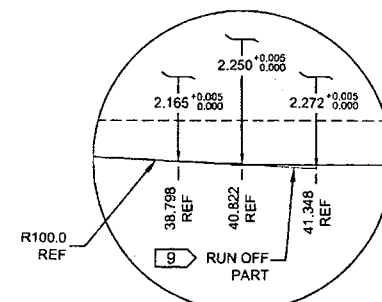
72485



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
B5-4 NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C3-4 NOT TO SCALE

RELEASED
08/11/13

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
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